



Dart Aerospace Ltd.
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D5404-041

Job Sheet 204610



Part No: D5404-041

Job Qty: 4 pcs

Part Name: LH Heavy-Duty Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/16/19

Job Tracking No:

Due Date: 12/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5404 REV.C SHEET 1 IPP REV:A 16.03.23 NEW ISSUE DD VERF:JLM IPP REV:B 17.01.05 AS PER DWG REV.A DD VERF:JLM IPP REV:C 19.05.16 AS PER DWG REV.B DD VERF:JFS/IPP Rev.D 19.11.21 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	12/20/19		0.00	3.20	Large Fab - 1		<i>ML</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	4 pcs	12/20/19		0.00	0.00	QC 9 - 10		<i>GL</i>
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
120	QC 5	4 pcs	12/20/19		0.00	0.00	QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S242614



Part No: D5404-041

Job No: 204610

Serial No/Batch: S242614

Revision: C
Inspector:

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					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	12/20/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DEC 24 2019
					QC 21 - SA - 53	

Part Op 100 - 1- Weld D4155-041 to wearplate as per dwg D5404 304 S.S. Welding Rod BATCH #: M434018 2-
 Descriptions: Transfer drill holes in bar 3- Use DT9684 to check fit after welding 4- Cut extra material on back end of wearplate if
 necessary 5- ENSURE WELDED CLAMP FITS AROUND A 3.23" DIAMETER WITH 0.375-0.500 THREAD EXPOSED
 WHEN SNUG.
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 150 - BATCH: M434018 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040
 THICK, PER DART QSI 005 4.9. 5235921
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4155-041	Wearbar Assembly	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5241226
D5404-1	Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5234836
D5617-3	Clamp	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	5238312
D5678-1	Hex Nut	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	5225308

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D4155-041	4	6	0
	D5404-1	4	5	0
	D5617-3	12	30	0
	D5678-1	12	45	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				